

ABSTRACT

First and second end surface truing sections are formed by protruding cylindrical first and second base bodies from opposite end surfaces of a disc-like base of an opposite end surface truing tool in the axial direction thereof and by providing on the external surface of the first base body and the internal surface of the second base body first and second abrasive grain layers in which numerous diamond abrasive grains are adhered with bond material. The rotational axis of the opposite end surface truing tool is inclined relative to the rotational axis of the grinding wheel within almost the same plane at a predetermined inclination angle. By moving the opposite end surface truing tool toward the rotational axis of the grinding wheel, the first and second abrasive grain layers respectively true the grinding surfaces at the opposite ends of the grinding wheel under almost the same condition to sharp grinding surfaces having moderate ruggedness, as they go ahead of the first and second base bodies to be backed up thereby. Consequently, it can be realized to true the grinding surfaces at the opposite ends of the grinding wheel under almost the same condition to the sharp grinding surfaces having the moderate ruggedness.